

# Work Order ID 45678-3 -1

September 30, 2009 7:27:49 AM



Page 1

Item ID: D3651-041  
Revision ID: B  
Item Name: Alt Base Assembly

Accept



Setup Start



Stop



Start Date: 9/30/09 Start Qty: 4.00  
Required Date: 10/09/09 Req'd Qty: 1.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date:   
QC: Date:

Tooling: Date:   
SPC (Y/N): Date:

Run Start  
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3651	Rev B								
100	Pick Kit	0.00							
Packaging									
Packaging	Memo	0.00							
110		0.00							
	Small Fab								
Small Fab									
Small Fab	Memo	0.00							
	1-Assemble as per dwg D3651 2- Seal all mating surfaces and gaps using Proseal 700 fire wall sealant as per dwg D3651 Batch: <u>M110624</u> 3-install D3651-1 using 3M high performance contact adhesive 1357 as per dwg D3651 Batch: <u>105623</u>								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC									
Quality Control	Memo	0.00							

*SB 09/09/29*

*SB 09/09/29*

*⇒ 50101/30*

*(46) 4*

# Work Order ID 45678-3

September 30, 2009 7:27:49 AM



Item ID: D3651-041  
Revision ID: B  
Item Name: Aft Base Assembly

Accept



Setup Start



Stop



Start Date: 9/30/09 Start Qty: 1.00



Required Date: 10/09/09 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:  
QC:

Date:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

GA so 02/09/29

8

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/05

Bl 09-10-2

# Picklist Print

September 30, 2009 7:27:48 AM

Work Order ID: 45678-3

Parent Item: D3651-041RevB

Parent Item Name: Aft Base Assembly


Comments:

Start Date: 9/30/09

Required Date: 10/09/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CR3523-4-02		Purchased	No			100	Each	422.0000	58.0000			
												
RIVET												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	422	
110914	1	
111127	21	
111359	100	
112278	100	
112794	200	

D3651-043RevB	Manufactured	No				110	Each	6.0000	1.0000			
												
Flange Weldment												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	42114	
45830	6	

D3651-111RevB	Manufactured	No				110	Each	11.0000	1.0000			
												
Gasket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	11	
44675	5	
45452	6	

22 88 09/09/29

22

88 09/09/29

4 88 09/09/29

# Picklist Print

September 30, 2009 7:27:48 AM

Work Order ID: 45678-3

Parent Item: D3651-041RevB

Parent Item Name: Alt Base Assembly

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3651-13RevB		Manufactured	No.			110	Each	7.0000	1.0000			
Outside Doubler												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	7	
ST	1	
42117	4	
44676	2	
45453		

D3651-1RevB

Manufactured No

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	7	
ST	2	
44674	5	
45831		

Start Date: 9/30/09

Start Qty: 1.00

Required Date: 10/09/09

Required Qty: 1.00

4 8/9/09/229

4 8/9/09/25

September 30, 2009 7:27:48 AM

Shop Packet Print

# Picklist Print

September 30, 2009 7:27:48 AM

Work Order ID: 45678-3

Parent Item: D3651-041RevB

Parent Item Name: All Base Assembly

Comments:

Component Item ID/  
Item Name

Replacement  
Item ID

Mfg/  
Purch

Bin  
Item

Primary  
Location

Last  
Location

Route  
Seq ID

Unit of  
Measure

Qty on  
Hand

Remaining  
Qty To Pick

Qty  
Issued

Date  
Issued

Status

D3651-9RevB



Inside Doubler

Manufactured

No

110

Each

10.0000

1.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

10

35847

1

44677

5

45451

4

Start Date: 9/30/09

Start Qty: 1.00

Required Date: 10/09/09

Required Qty: 1.00

4 809/09/29 (4)

Shop Packet Print

September 30, 2009 7:27:48 AM



Date: Tuesday, 10/02/2009 1:08:58 PM  
User: Melanie Fauteux

## Process Sheet

Split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT BASE ASS'Y
Job Number	: 45678 -- \		
Estimate Number	: 13043		
P.O. Number	:	Part Number	: D3651041
This Issue	: 10/02/2009 S.O. No. :	Drawing Number	: D3651 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: B
Previous Run	: 42040	Material	:
Written By	:	Due Date	: 17/02/2009
Checked & Approved By	: <u>mf 09-02-10</u>	Qty:	4 Um: Each
Comment	Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD verified by: EC Est Rev:C ecn1162 08-04-02 DD verified by: EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

2.0	✓ D3651043	Flange Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
FLANGE ASSEMBLY B 42114

FF 09/02/25 (4)

3.0	✓ D36511	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
GASKET B 44674

FF 09/02/25 (4)

4.0	✓ D36519	Inside Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
DOUBLER B 45451

FF 09/02/25 (4)

5.0	✓ D365111	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
GASKET B 45452

FF 09/02/25 (4)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE ASS'Y

Job Number: 45678

Part Number: D3651041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

✓ D365113

Outside Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

DOUBLER

B 45453

FF 09/02/25 (4)

7.0

✓ CR3523402

RIVET



M112278



FF 09/02/25

Comment: Qty.: 58.0000 Each(s)/Unit Total: 232.0000 Each(s)

RIVET

M110914

M11127 (22P)

FF 09/02/25 (4)

8.0

✓ SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: 1-Assemble as per dwg D3651

2- Seal all mating surfaces and gaps using Proseal 700 fire wall sealant as per dwg D3651

Batch: M110624

3-install D3651-1 using 3M high performance contact adhesive 1357 as per dwg D3651

Batch: M105623

FF 09/02/26 (4)

9.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/30 (4)

10.0

✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: \_\_\_\_\_

11.0

✓ QC21

FINAL INSPECTION/W/O RELEASE

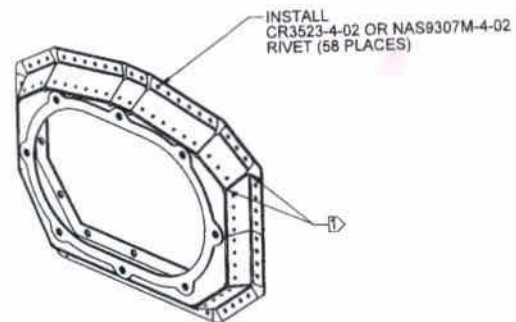
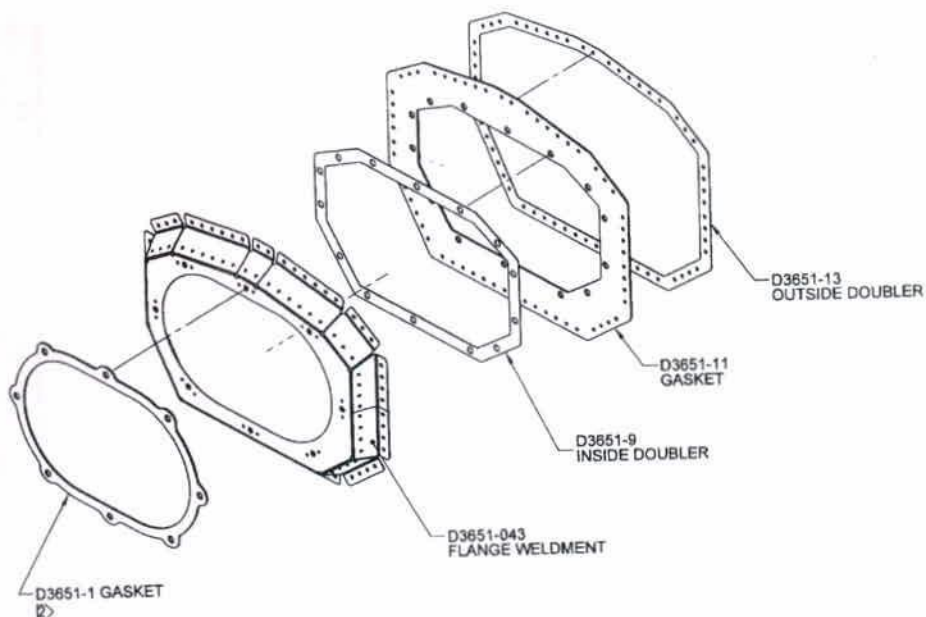


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion







#### PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

#### D3651-041 AFT BASE ASSEMBLY

##### D3651-041 NOTES:

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50 0.88 WAS 0.98 REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9 GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
REV	NEW ISSUE	RF	07.11.07
DESIGN	RF	BY	DATE
DRAWN	RF		
CHECKED	LE		
MFG. APPR	DA		
APPROVED	DA		
DE APPR	DA		
DATE	08.01.07		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3651</b> TITLE <b>AFT BASE ASSEMBLY</b> SCALE 1:1 SHEET 1 OF 9 REV. B			

REFERENCE ONLY

# 45878

11/08/07 27/NOV